

DEL 1.25

## Work Order ID 84943

\*84943\*

Page 1

May-29-12 1:12:25 PM

Item ID: D3417-5

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Washer

Start Date: 29/05/2012 Start Qty: 40.00

\*40\*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 40.00

\*40\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/30

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3417

Rev F

100

0.00

\*100\*

Hardinge CNC LATHE SMALL

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA761

Rev: \_\_\_\_\_ &amp;

Dwg D3417 Rev: \_\_\_\_\_

2-Deburr

SA 125619

40  $\phi$ 

110

0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 125619

40  $\phi$ 

120

0.00

\*120\*

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SA 12/06/11

40  $\phi$

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 84943****\*84943\***

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Item ID: D3417-5

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Washer

Start Date: 29/05/2012 Start Qty: 40.00

**\*40\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 40.00

**\*40\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>STY 2</u>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00				<u>40</u>		<u>54</u>	<u>12/06/11</u>
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

MF  
12-06-11

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

May-29-12 1:12:28 PM

Page 1

Work Order ID: 84943

\*84943\*

Parent Item: D3417-5

\*D3417-5\*

Parent Item Name: Washer

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev: A New issue 08-07-09 JLM Verified By: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDEL RINR1.2500

Purchased

No

110

f

9.4770

0.0296

1.246316

**\*MDFI RINR1 2500\***

\*\*

SD 12/6/9

DEL RIN ROUND BAR 1.25"

Location

Loc Qty

Loc Code

MAT055

9.477

114586

1.449

119133

8.028

1.5 PL

28 notes

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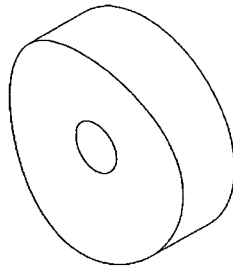
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

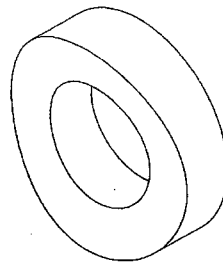
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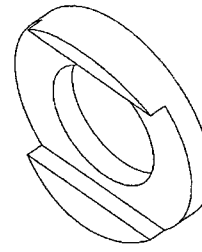




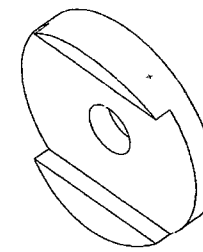
D3417-1 WASHER



D3417-3 WASHER

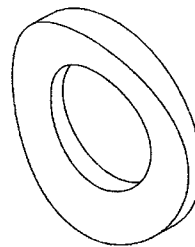


D3417-5 WASHER



D3417-7 WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84943 MLJ  
12/05/30



D3417-9 WASHER

**RELEASED**  
2010-09-15  
*mlj*

**NOTES:**

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD  
REF DART SPEC M-DELIN-R  
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR  
REF DART SPEC M-DELIN-B  
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET  
REF DART SPEC M-DELIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs  
D3417-3, 0.010 lbs  
D3417-5, 0.010 lbs  
D3417-7, 0.010 lbs  
D3417-9, 0.004 lbs

F	ADD D3417-9 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.06.30
D	ADD -5 WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	10.07.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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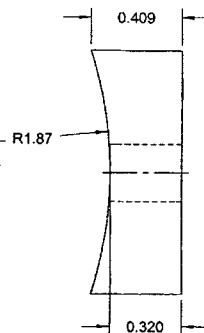
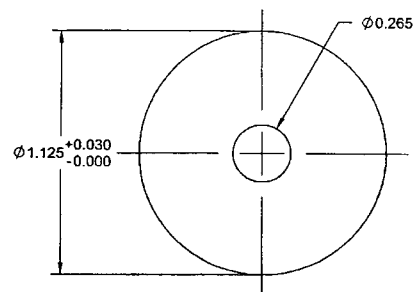
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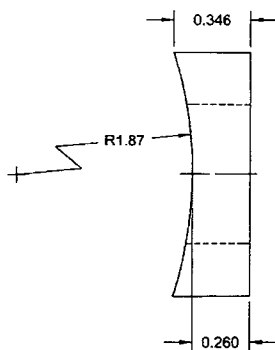
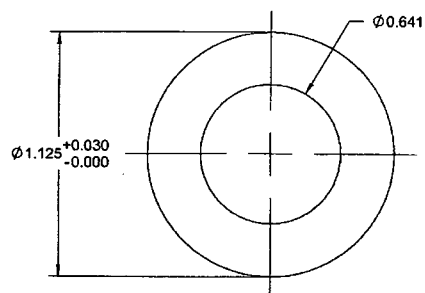
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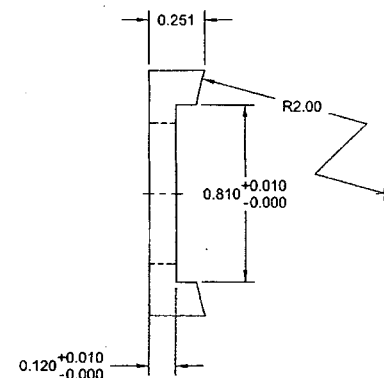
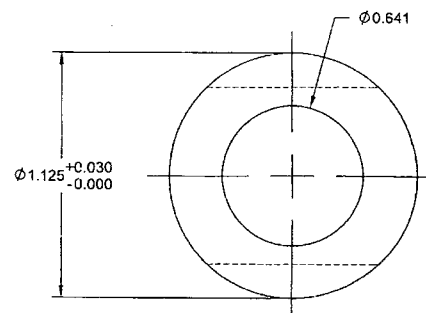
84943



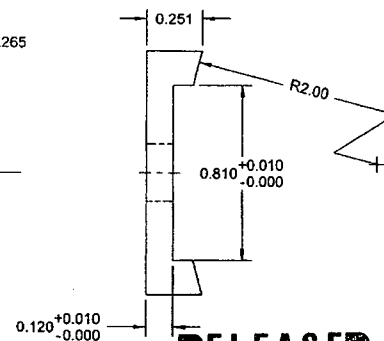
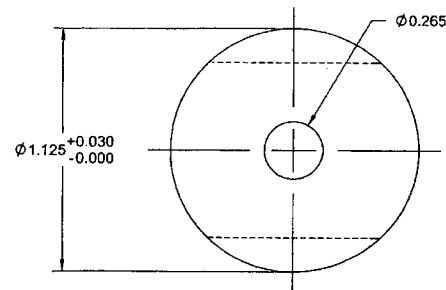
**D3417-1 WASHER**



**D3417-3 WASHER**



**D3417-5 WASHER**



**D3417-7 WASHER**

**RELEASED**  
2010-09-15

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CHECKED		DRAWING NO. <b>D3417</b>	REV. F
MFG. APPR.		TITLE <b>WASHER</b>	SHEET 2 OF 3
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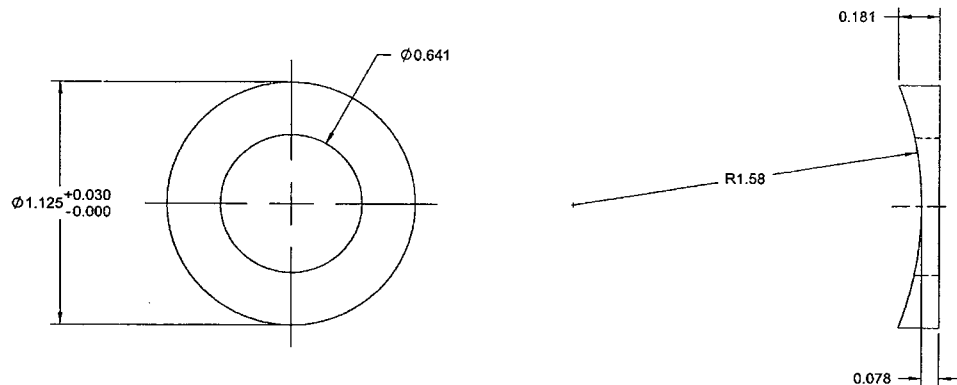
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**D3417-9 WASHER**



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